

Date Opened: 14 May 2014

Approval Information:

Approval: **Multiple**

Document Control List: Multiple

Approval on AML: Y / NDCL meets/exceeds revision on STC: Y / N

Part Information:

Fabrication Drawing: 69830, Rev. 3

Matches DCL: Y / N

Qty	Part Number	Description	Material
100	69830-07	Block	304 Stainless Steel, 0.188 x 0.75

PO 61908

stop

Processes

☐ Painting☐ Powder Coating☐ Anodizing

PO

Tests/Inspections specified on drawings? Y / N

Test/Inspections complete? Initial: _____

Final Inspection

Initial: AK

Work Order pre-completion Inspection:

Release tags required?

Y / N

(Release tags are not required if part can only be used as part of a further assembly)

Release tags complete?

Y / N

Interim tracking tags complete: Y / N

List all non-conformities raised: _____

Asen Reh

Inspector Signature:

14 May 14.

Date:

This form is intended for batch production of component parts only.



WO# 2014-49

Approved Manufacturing Facility 73-04 Form 20.F.06 Rev. Original 27 May 2013

2014-49

01 FORWARD BEAM ASSEMBLY
02 FORWARD BEAM ASSEMBLY

03 BUSHING
04 STRAP
05 BLOCK
06 CAP
07 GUIDE
08 STOP
09 KNOB
10 SPRING
11 KNOB

DETAIL A

LIST OF MATERIALS - STEEL BEAM

QTY	PART NO.	ITEM	DESCRIPTION	MATERIAL	MATERIAL SPEC	STOCK SIZE
1	01	FORWARD BEAM ASSEMBLY	FORWARD BEAM ASSEMBLY	STEEL	15mm x 70mm SPIND	
1	02	FORWARD BEAM ASSEMBLY	FORWARD BEAM ASSEMBLY	STEEL	15mm x 70mm SPIND	
1	03	FORWARD BEAM ASSEMBLY	FORWARD BEAM ASSEMBLY	STEEL	15mm x 70mm SPIND	
1	04	FORWARD BEAM ASSEMBLY	FORWARD BEAM ASSEMBLY	STEEL	15mm x 70mm SPIND	
1	05	FORWARD BEAM ASSEMBLY	FORWARD BEAM ASSEMBLY	STEEL	15mm x 70mm SPIND	
1	06	FORWARD BEAM ASSEMBLY	FORWARD BEAM ASSEMBLY	STEEL	15mm x 70mm SPIND	
1	07	FORWARD BEAM ASSEMBLY	FORWARD BEAM ASSEMBLY	STEEL	15mm x 70mm SPIND	
1	08	FORWARD BEAM ASSEMBLY	FORWARD BEAM ASSEMBLY	STEEL	15mm x 70mm SPIND	
1	09	FORWARD BEAM ASSEMBLY	FORWARD BEAM ASSEMBLY	STEEL	15mm x 70mm SPIND	
1	10	FORWARD BEAM ASSEMBLY	FORWARD BEAM ASSEMBLY	STEEL	15mm x 70mm SPIND	
1	11	FORWARD BEAM ASSEMBLY	FORWARD BEAM ASSEMBLY	STEEL	15mm x 70mm SPIND	
1	12	FORWARD BEAM ASSEMBLY	FORWARD BEAM ASSEMBLY	STEEL	15mm x 70mm SPIND	
1	13	FORWARD BEAM ASSEMBLY	FORWARD BEAM ASSEMBLY	STEEL	15mm x 70mm SPIND	
1	14	FORWARD BEAM ASSEMBLY	FORWARD BEAM ASSEMBLY	STEEL	15mm x 70mm SPIND	

NOTES

- REMOVE ALL BURRS AND BREAK SHARP EDGES.
- WELDING OF STEEL TO BE COMPLETED BY GTAW METHOD TO AMERICAN WELDING ROD SHALL CONFORM TO E7018-1 OR EQUIVALENT FOR ALUMINUM STEEL. WELDING ROD SHALL CONFORM TO EXX103 OR EQUIVALENT FOR STAINLESS STEEL.
- ALL STEEL PARTS TO BE THOROUGHLY DEGREASED AND POWDER COATED PRIOR TO INSTALLATION.
- FORWARD BEAM ASSEMBLY (00030-02) MAY BE USED AS A DIRECT REPLACEMENT FOR FORWARD BEAM ASSEMBLY (00030-01).

APPROVALS DATE

DESIGNED BY: KEVIN CLARKE 06 APR 2009

CHECKED BY: E. BURROGH

UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ON

DECIMALS ANGLES

X.XXX ±0.010 ±1/2°

X.XX ±0.01 ±1/2°

X.X ±0.1 ±1/2°

SHEET 1 OF 1

SCALE 1:1

A0 69830 3

BELL 208L / 407

QUICK RELEASE CARGO BASKET

FORWARD BEAM FABRICATION

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